DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018576
Date Inspected: 14-Dec-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name: Yu Dong Ping

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG COMPONENT

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection
Trial Assembly
This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG U-rib connected splice, UT repair weld No.USPLI-655-002. The welder is identified as #046709. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR .The weld repair report is identified as WR19045.

SMAW in the 1G position for the OBG U-rib connected splice, UT repair weld No.USPLI-656-001. The welder is identified as #046704. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR .The weld repair report is identified as WR19046.

BAY#10
This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG bike path, weld No.BK004-A1-025-032. The welder is identified as

#040533. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2332-ESAB.

FCAW in the 2G position for the OBG bike path, weld No.BK004-A1-028-030. The welder is identified as #040434. ZPMC QC is identified as Mr. Li Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2332-ESAB.

BAY#11

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Bike path , weld No.BK004-A3-054-073. The welder is identified as #054460. ZPMC QC is identified as Mr. Shao Hai Lang . The welding variables recorded by QC appear to comply with WPS-B-P-2112.

SMAW in the 2F position for the OBG Bike path , weld No.BK004-A3-020-073. The welder is identified as #040723. ZPMC QC is identified as Mr. Shao Hai Lang . The welding variables recorded by QC appear to comply with WPS-B-P-2112.

BAY#8

This QA Inspector observed the following work in progress:

SMAW in the 1G position for the OBG bike path, UT repair weld No.BK004-A1-063-044. The welder is identified as #037996. ZPMC QC is identified as Mr. Feng Ya Jun . The welding variables recorded by QC appear to comply with WPS-345-SMAW-1G(1F)-REPAIR. The weld repair report is identified as WR18888.

FCAW in the 1G position for the OBG bike path, weld No.BK004-A2-063-016. The welder is identified as #500405. ZPMC QC is identified as Mr. Feng Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-T-2231-ESAB.

During a random visual inspection of Bike path BK004A-061 the Quality Assurance Inspector was observed excessive root openings on PJP weld joint. According to approve drawing weld details and the approved WPS, the tolerance for root opening is 0mm(+3,-2) maximum. The recorded root opening was 6mm. The weld is identified as: BK004A8-061-002 corner weld between deck plate to Side plate(BKPL8B). The Y location of more root gap at 0 mm to 300 mm (Measuring from outer side). The Weld is a Partial Joint Penetration (PJP) Butt weld. The OBG Bike path is located at Bay#8.

This QA inspector generated an incident report on this date.

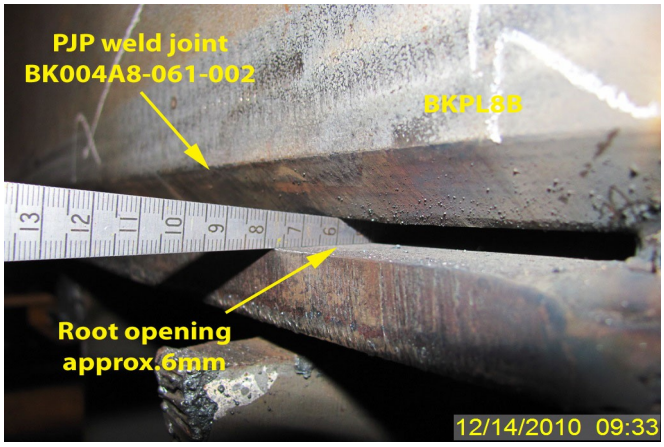
Magnetic Particle Testing (MPT) for bike path at Bay#8

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG bike path weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

BKASD1-058-007,008,015,017,025,026,019,020

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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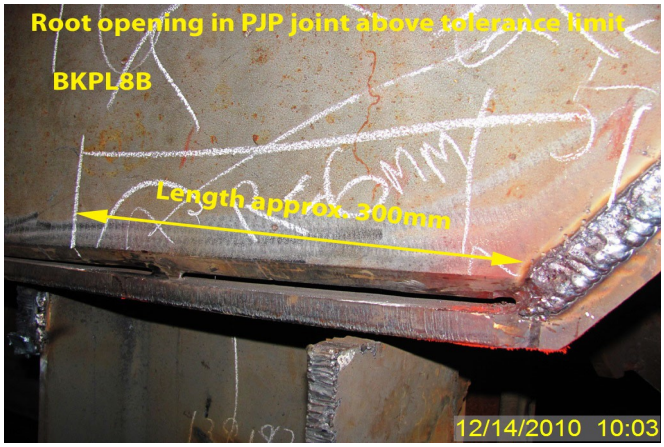

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer